












Date: Tuesday, 07/04/2009 10:18:34 AM
 User: Julie Dawson

Process Sheet

| | | | |
|---|---|---|--|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : CROSSBOLT SPACER |
| Job Number | : 46956 | Part Number | : D2579 |
| Estimate Number | : 10993 | Drawing Number | : D2579 REV E |
| P.O. Number | : | Project Number | : N/A |
| This Issue | : 07/04/2009 S.O. No. : | Drawing Revision | : E |
| Prsht Rev. | : NC | Material | : |
| First Issue | : / / Type : MACHINED PARTS | Due Date | : 22/04/2009 Qty: 200 Um: Each |
| Previous Run | : 46434 | | |
| Written By | : | | |
| Checked & Approved By | : <u>JUD 09.04.07</u> | | |
| Comment | : Est E 02.06.17 Now turned on Cobra NG est F 07.07.06 rev E dwg EC | | |
| Additional Product | | | |
| Job Number:  | | | |
| Seq. #: | Machine Or Operation: | Description : | |
| 1.0 | M6061T6T0500W058 | 6061-T6 RD Tube .500 x.058W | |
| |  |  | |
| Comment: Qty.: 0.3762 f(s)/Unit Total: 75.2430 f(s) 6061-T6 Tube .500 x.058W Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4) 0.500 Dia x 0.058 Wall Batch <u>4110335</u> <u>ml 09/04/12</u> (200) | | | |
| 2.0 | HARDINGE <u>DART</u> | HARDINGE CNC LATHE SMALL | |
| |  |  | |
| Comment: HARDINGE CNC LATHE SMALL Machine as per Folio 1245 <u>Day D2579</u> <u>ml 09/04/12</u> (200) | | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| |  |  | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>ml 09/04/12</u> (200) | | | |
| 4.0 | QC8 | SECOND CHECK | |
| |  |  | |
| Comment: SECOND CHECK <u>M.A</u> <u>09/04/13</u> (200) | | | |
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 | |
| |  |  | |
| Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>Barthay</u> <u>9/4/14</u> <u>SW</u> (200) | | | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:18:34 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 46956

Part Number: D2579

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/14 HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 09.04.14

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

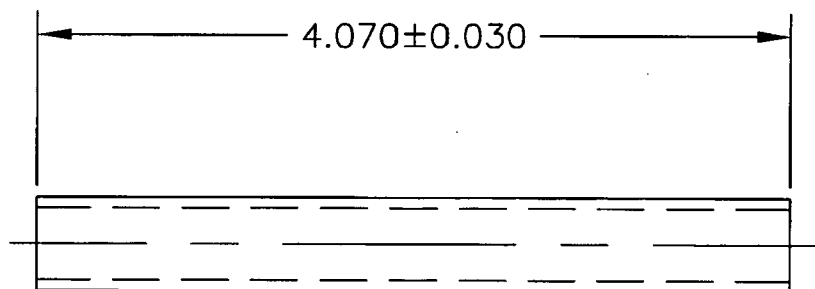
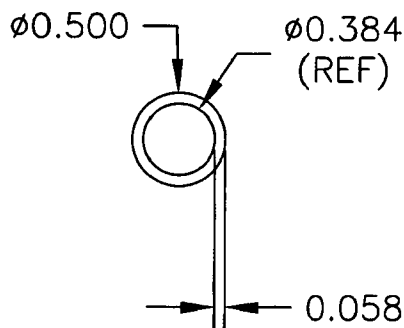
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|------------------|----------------|---|------------------------|
| DESIGN # | DRAWN BY RA | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D2579 | REV. E SHEET 1 OF 1 |
| DATE 07.04.17 | | TITLE CROSS BOLT SPACER | SCALE 1:1 |
| A | 96.09.16 | NEW ISSUE | |
| B | 96.12.05 | 0.065 WALL WAS 0.035 WALL | |
| C | 97.02.21 | 0.058 WALL WAS 0.065 WALL | |
| D | 99.05.19 | 4.070 LENGTH WAS 4.100 (TSR A1095) | |
| E | 07.04.17 | UPDATE NOTES | |

RELEASED
07.06.28**D2579 CROSS BOLT SPACER****D2579 CROSS BOLT SPACER**

- 1) MATERIAL: 6061-T6 TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6T0500W058)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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